

Work Order ID 61705

Tuesday, August 31, 2010 1:20:25 PM



Page 1

Item ID: D2056

Accept



Setup Start



Revision ID:

Item Name: Bell Crank

Stop



Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10-8-8*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2056

Rev B2

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 2.80" long

SL 10/09/29

1.250" x 1.250"
Batch: 110001

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2056
Tumble
Deburr

ent 10/10/01

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ent 10/10/01

9/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2056 PAR #: _____ Fault Category: machining NCR: Yes No DQA: J Date: 10/01/01
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: J Date: 10/01/01

NCR: <u>61705</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/01/01</u>	<u>110</u>	<u>1 part scrap, part left during machining (last part).</u> <u>R.C. process</u>	<u>[Signature]</u> <u>05/04/02</u>	<u>scrap and replace</u> <u>no replace no more material</u> <u>Qty (x1)</u>	<u>[Signature]</u> <u>10/01/01</u>	<u>[Signature]</u> <u>10/01/01</u>	<u>[Signature]</u> <u>05/04/02</u>	<u>[Signature]</u> <u>10/01/01</u>

NOTE: Date & initial all entries

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 61705

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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Bell Crank

Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/10/05

9

0

170

Identify as per dwg & Stock Location 006

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05

NF
10-10-05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	<i>61705</i>
Description: Bell Crank		Part Number:	D2056
Inspection Dwg: D2056 Rev: B2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	<i>.754</i>	<i>—</i>		<i>Vern</i>	<i>ML-7</i>
0.900	+/-0.010	<i>.903</i>	<i>—</i>		<i>Vern</i>	<i>"</i>
1.000	+/-0.010	<i>1.009</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.125	+/-0.010	<i>.127</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.060	+/-0.010	<i>.062</i>	<i>—</i>		<i>Micro</i>	<i>ML-01</i>
Ø0.191	+0.005/-0.001	<i>Ø.192</i>	<i>—</i>		<i>Vern</i>	<i>ML-7</i>
0.362	+/-0.010	<i>.360</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.750	+/-0.010	<i>.752</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.385	+/-0.010	<i>.385</i>	<i>—</i>		<i>"</i>	<i>"</i>
Ø0.257	+0.006/-0.001	<i>Ø.259</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.100	+/-0.010	<i>.102</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.300	+/-0.010	<i>.300</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.946	+/-0.010	<i>.946</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.075	+/-0.010	<i>.075</i>	<i>—</i>		<i>"</i>	<i>"</i>
2.637	+/-0.010	<i>2.641</i>	<i>—</i>		<i>"</i>	<i>"</i>
0.375	+/-0.010	<i>.375</i>	<i>—</i>		<i>"</i>	<i>"</i>
Ø0.513-0.518	0.513 - 0.518	<i>Ø.517</i>	<i>—</i>		<i>"</i>	<i>"</i>
R0.450	+/-0.010	<i>R.450</i>	<i>—</i>		<i>Rad-gage</i>	<i>REF</i>
R0.125	+/-0.010	<i>R.125</i>	<i>—</i>		<i>"</i>	<i>"</i>
R0.200	+/-0.010	<i>R.200</i>	<i>—</i>		<i>"</i>	<i>"</i>
R0.550	+/-0.010	<i>R.550</i>	<i>—</i>		<i>"</i>	<i>"</i>
R0.263	+/-0.010	<i>R.263</i>			<i>"</i>	<i>"</i>

Measured by:	<i>ML</i>	Audited by:	<i>B.A</i>	Prototype Approval:	N/A
Date:	<i>10/02/01</i>	Date:	<i>10/10/01</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	<i>[Signature]</i>

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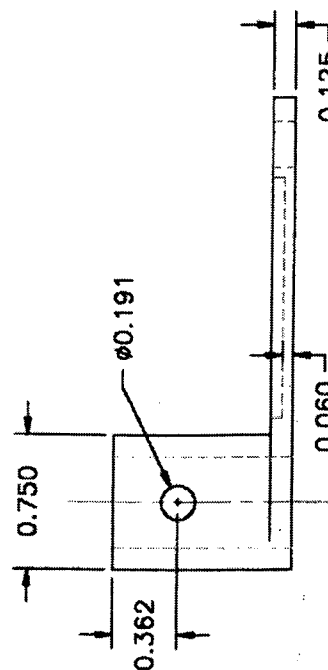
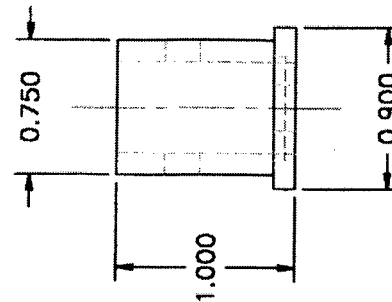
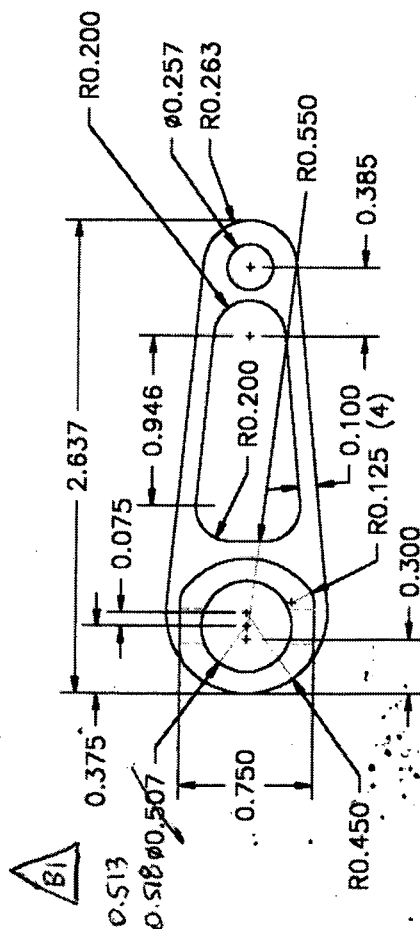
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. B
CHECKED BN	APPROVED KE	D2056	SHEET 1 OF 1
DATE	TITLE	SCALE	
92:03:13	BELL CRANK	1:1	
B	95:11:02	RE-DESIGN	
B1	01.06.04	MODIFY HOLE SIZE, ADD PIC OPTION	
B2	01.12.20	ADD NOTE ON TOLERANCES	

RELEASED
99.04.29 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66705
BR0-8-31



ACID ETCH & ALUMINE PER
DART QSE DQS 4.1
POWER COAT BLACK SIGNATURE
(4.3.5.7) PER DART
QSE DQS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QSE 01B UNLESS OTHERWISE NOTED.

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